

Work Order ID 85125

June-04-12 8:20:50 AM

85125

Page 1

Item ID: D350-591-213

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/04 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3078	A
-------	---

DSI 9472	A
----------	---

100		0.00
-----	--	------

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003

DAS 16 17/6/17 JB

MLJ 12-7-17 (5)

110		0.00
-----	--	------

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

5 0 Ae 12-06-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Revision ID:

Item Name: Heli-Access-Step, Short LH

Stop ***NS2***

Start Date: 04/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

Scalorhi

45

47

5

26 12-7-11

5

φ

12 07.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 04/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Chemical Conversion Coat per QSI005 4.1	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing									
						SX	Ø		ML
						LH			12/07/16
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:10								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 12:40								
	Wing Walk as per dwg QSI005 4.4 Batch 121505	0.00							
250									
HandFinish	Memo	0.00							
Hand Finishing									
						SX	Ø		ML
						LH			12/07/16
						SX	Ø		ML
						LH			12/07/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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June-04-12 8:20:50 AM

85125

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 04/06/2012 **Start Qty:** 5.00

5

Customer:

Required Date: 18/06/2012 **Req'd Qty:** 5.00

5

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

260

QC3- Inspect Part Finish

0.00

260

QC

Memo

0.00

Quality Control

270

Pick Kit

0.00

270

Packaging

Memo

0.00

Packaging

280

QC4- 100% Inspect kits for completeness

0.00

280

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop ***NS2***

Start Date: 04/06/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	Packaging	0.00							
290									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-213								
	Location: <u> </u>								
	PPP Rev: <u> </u>								
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

5012/7/1712/7/18UMF12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 85125

85125

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM

IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D

10.03.17 incorporate seq 180 to 200 remove qc5 DD verified

by:JLM

IPP Rev:E

10.11.15 update qty on AN4-11A DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			110	Each	156.6100	0.5	2.5			

D2622-120C

Step Extrusion

**

Ae 12.06.26

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA

130.88

81507

4.88

83894

126

WA013

9.36

75781

2

77612

7.36

2.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 85125

85125

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3067-1

Manufactured No

130

Each

172.0000

1

5

D3067-1

End Plate

**

12.07.03

Location

Loc Qty

Loc Code

WA

139

78608

4

83855

60

84534

75

WA016

33

67582

2

68214

1

79607

1

83053

29

D3063-1

Manufactured No

130

Each

53.0000

1

5

D3063-1

Support

**

12.07.03

Location

Loc Qty

Loc Code

WA016

53

71886

53

MS20600-AD4W4

Purchased No

180

Each

3,464.000

16

80

MS20600-AD4W4

Rivets

**

12.07.12

Location

Loc Qty

Loc Code

321

1000

121652

1000

ST321

2324

121011

9

121340

315

121444

2000

WA018

140

118840

140

80

June-04-12 8:20:55 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 3

Work Order ID: 85125

85125

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

D3066-1	Manufactured	No	180	Each	71.0000	2	10
---------	--------------	----	-----	------	---------	---	----

D3066-1
Spacer

**

Ac 12.07.12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST176	71	
<u>83854</u>	71	

D3065-041	Manufactured	No	180	Each	13.0000	1	
-----------	--------------	----	-----	------	---------	---	--

D3065-041
Step Leg Assembly Hi

**

10

383871 (5) Ac 12.07.12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	13	
66149	0	
79336	1	
80880	12	

D3067-1	Manufactured	No	200	Each	172.0000	1	5
---------	--------------	----	-----	------	----------	---	---

D3067-1
End Plate

**

Ac 12.07.17

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	139	
78608	4	
83855	60	
<u>84534</u>	75	
WA016	33	
67582	2	
68214	1	
79607	1	
83053	29	

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 85125

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125

D350-591-213

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN3-35A Purchased No

270 Each

116.0000

2 10

AN3-35A

Bolt

**

Location

Loc Qty

Loc Code

ST353

116

121652

116

D2856-400 Manufactured No

270 f

230.5445

0.6

D2856-400

Abrasion Strip

**

Location

Loc Qty

Loc Code

ST403

216

81875

216

ST409

14.5445

63735

0.6696

68076

0.3149

71164

8.46

79551

5.1

cut qty of 1 at 4.00" X 7.20" as per dwg (D2856-400-720)

AN4-11A Purchased No

270 Each

296.0000

2 10

AN4-11A

Bolt

**

Location

Loc Qty

Loc Code

ST356

296

118706

46

120731

100

121243

50

121708

100

June-04-12 8:20:55 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 5

Work Order ID: 85125

85125

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN960JD416

NAS1149D0463J

Purchased

No

270

Each

30.0000

12

60

✓

AN960JD416

Washer

**

121912

JB



Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

D2230-1

Manufactured

No

270

Each

20.0000

2

10

✓

D2230-1

Lug

**

84135

JB



Location

Loc Qty

Loc Code

ST480

20

83273

20

MS21042L3

Purchased

No

270

Each

2,195.000

2

10

✓

MS21042L3

Nut

**

JB

12/07/12



Location

Loc Qty

Loc Code

ST300

2195

117885

32

119017

952

119075

138

121349

221

121444

852

121444

June-04-12 8:20:55 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
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Work Order ID: 85125

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

85125

D350-591-213

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

AN4-13A

Purchased

No

270

Each

1,261.000

4

20

**

AN4-13A

Bolt

Location

Loc Qty

Loc Code

ST357

1261

119449

33

120187

19

120422

2

120770

207

121652

1000

D2732

Manufactured

No

270

f

520.9153

1

5.263158

**

D2732

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

520.915299

70987

20.915299

83560

500

cut qty of 4 at 100% as per dwg(D2732-030)

D2230-3

Manufactured

No

270

Each

90.0000

2

10

**

D2230-3

Lug

Location

Loc Qty

Loc Code

ST480

90

83261

90

270

Each

0.0000

4

20

**

AN960ID10

NAS1149D0363J

Purchased

No

AN960.ID10

Washer

June-04-12 8:20:56 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

270

Each

3,910.000



30

✓

MS21042L4

Nut

**

20



Location

Loc Qty

Loc Code

ST300

3910

119075

116

121011

537

121444

2957

121652

300

121444



AN4-16A

Purchased

No

270

Each

169.0000



20

✓

AN4-16A

Bolt

**

13x122416

20

12/07/11

Location

Loc Qty

Loc Code

ST358

169

120498

14

121060

30

121444

75

121541

50

7x121444

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.07.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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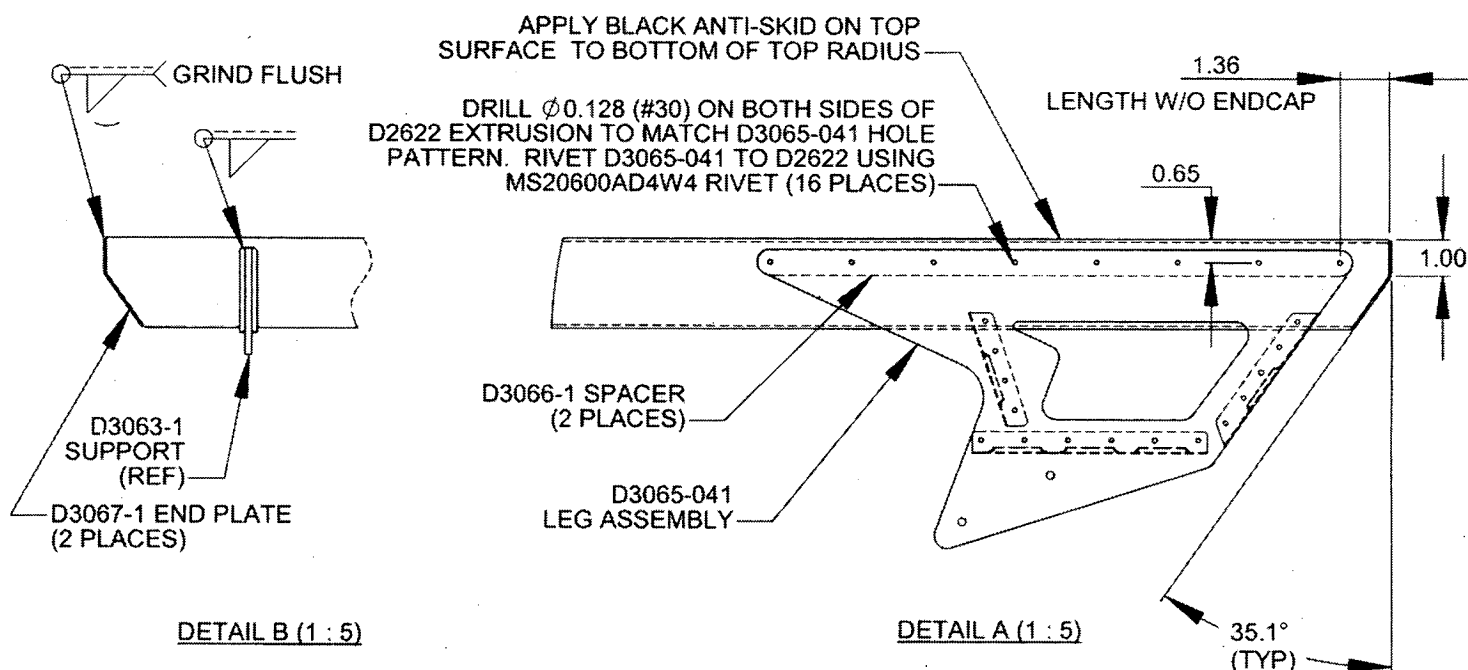
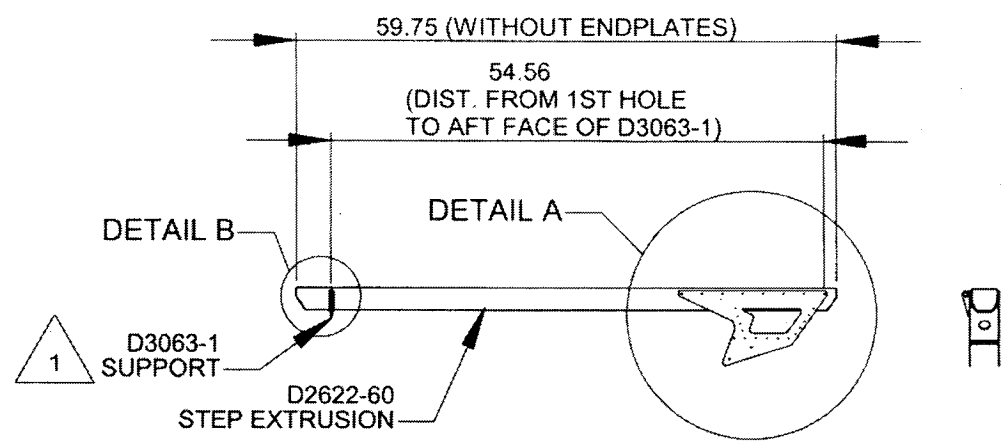
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DART



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DESIGN	DP	DRAWN BY	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	DP	APPROVED	DP	DRAWING NO. D3078
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	



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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.




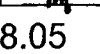
For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

09/08/05

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: 	
D. SHEPHERD (DE # 02)	
DATE:	09.08.05
CERT. NO.:	SH92-6
ISSUE NO.:	11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED			
MFG. APPR.	NCA		
APPROVED		DRAWING NO. REV. A	
DE APPR.		DSI 9472 SHEET 1 OF 2	
DATE	09.08.05	TITLE SCALE	
		BOLT ADDITION NTS	
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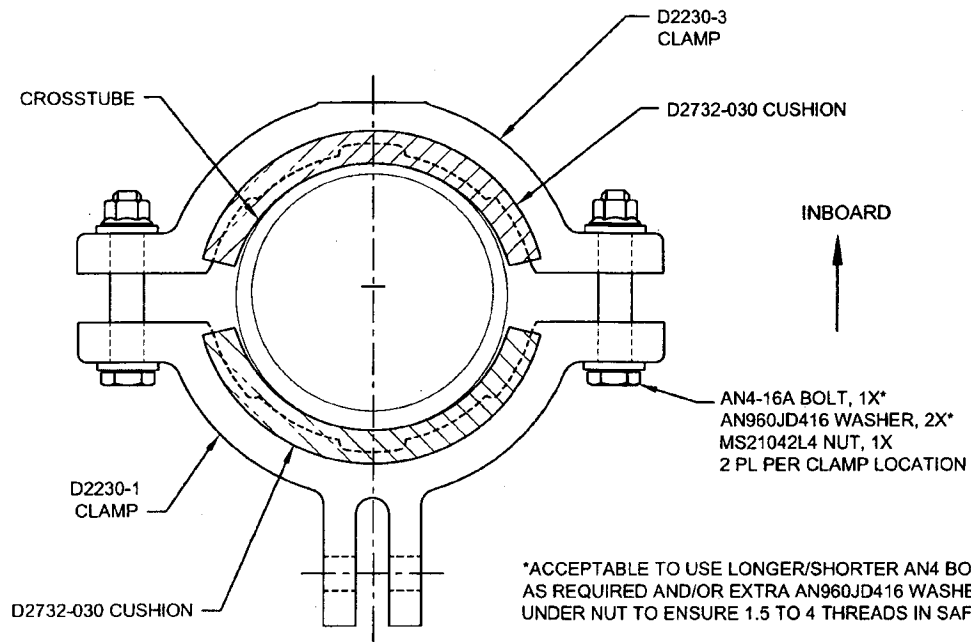


FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	<i>q</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>q</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT ADDITION	NTS
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05/12/05

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD446	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

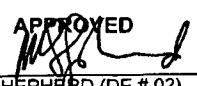
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AND
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

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	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
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DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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